

Work Order ID 75193

October-18-11 3:27:25 PM

75193

Page 1

Item ID: D2332-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lid Prop Assembly 6.69" long

Start Date: 18/10/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/11 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long. cut 20 pieces

3- Deburr.

SB 11/11/24

110

0.00

110

Brake NC

Memo

0.00

Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

SB 11/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 6.69" long
 Start Date: 18/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Small Fab

Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Quality Control

Memo

0.00

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
 *****ensure nothing is inside of tube before welding*****

S.S Rod batch: M114509

Ep 11/11/23 *(10x)*

(X9)

Q 11/11/28 *(X9)*

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Page 3

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Revision ID:

Stop ***NS2***

Item Name: Lid Prop Assembly 6.69" long

Start Date: 18/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170									
Small Fab	Memo	0.00							
Small Fab	1- Tumble								
	2- Assemble as per dwg D2332								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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75193

Page 4

October-18-11 3:27:25 PM

Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lid Prop Assembly 6.69" long
 Start Date: 18/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00				<u>nl</u>	<u>11</u>	<u>12</u>	<u>01</u> ⑦
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>ST 5/2</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

SP 11-12-1.

11/12/5 MF
11-12-01

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-18-11 3:27:29 PM

Page 1

Work Order ID: 75193

75193

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			100	f	8.1480	0.1	1.052632			
M304R 250									**	SB 11/11/24			
304 SS Round bar .250													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT028				8.14799943					
				114482				8.14799943			2		
M304TR1.000W.049		Purchased	No			100	f	13.9863	0.43	4.526316			
M304TR1 000W 049									**	SB 11/11/24			
304 RD Tube 1.00 x .049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT018				13.986315					
				111457				12.66			5		
				117598				1.326315					
M304TR0.500W.035		Purchased	No			110	f	183.6323	1.25	13.15789			
M304TR0 500W 035									**	SB 11/11/24			
304 RD Tube .500 x .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT017				183.6322723					
				115535				2.33					
				116720				1.66068					
				117598				22.6415923					
				118702				57					
				119160				100					

W/O:		WORK ORDER CHANGES					
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Picklist Print

October-18-11 3:27:29 PM

Page 2

Work Order ID: 75193

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

75193

D2332-041

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No

170 Each 44.0000 1 10

AN4-4A

Bolt

**

EP 11/12/01

Location

Loc Qty

Loc Code

FP-B

18

114615

18

ST356

26

114615

26

AN960JD416L NAS1149D0416J Purchased No

170 Each 11.0000 3 30

*AN960JD416I *

Washer

**

EP 11/12/01

47 11/18/13

240

Location

Loc Qty

Loc Code

FP-B

11

110153

11

MS21042L4 Purchased No

170 Each 14,058.00 1 10

MS21042I 4

Nut

**

EP 11/12/01

Location

Loc Qty

Loc Code

ST300

3058

117441

51

117601

557

117885

56

118451

1394

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

October-18-11 3:27:30 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

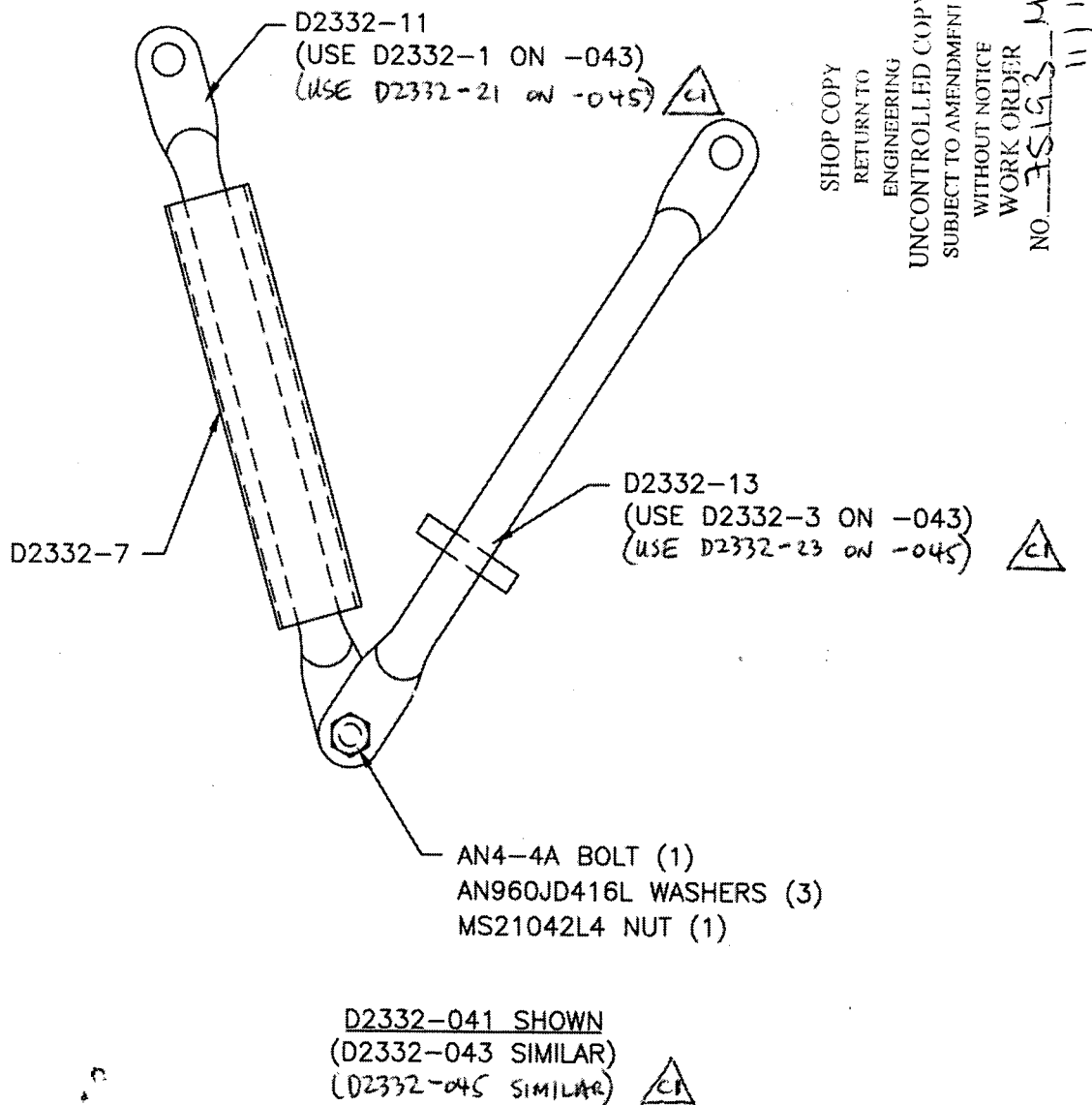
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

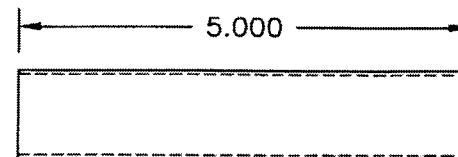
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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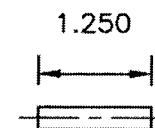
75193

DART

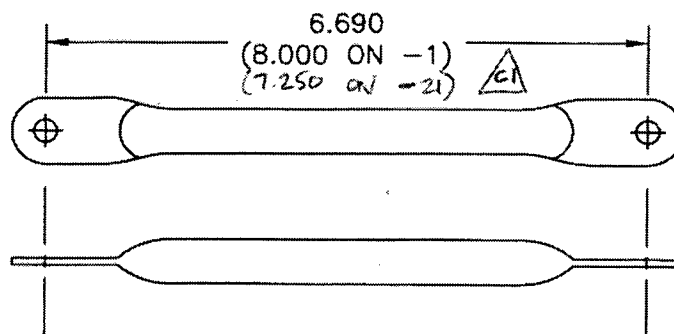
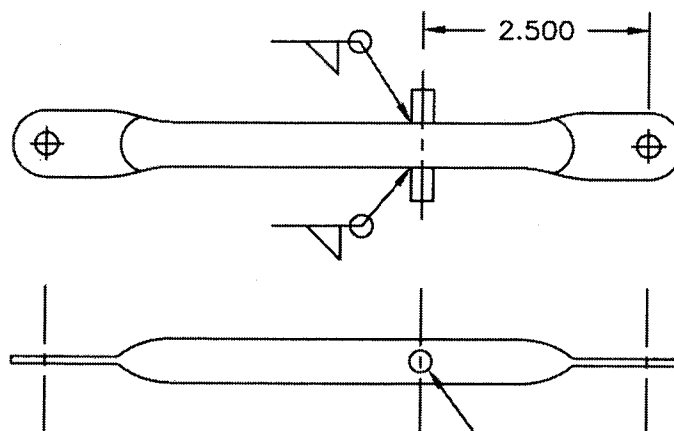
DESIGN	DRAWN BY	DART AEROSPACE LTD
C	03.07.03	MAKE -041 PROP 6.61" LONG (END)
C	03.07.03	MAKE -043 PROP 8.00" LONG (END)
C	03.08.06	ADD -045 PROP 7.25" LONG
DATE	03.07.03	LID PROP ASSEMBLY
CHECKED	APPROVED	DRAWING NO. D2332
		TITLE LID PROP ASSEMBLY
		SCALE 1:2
		SHEET 2 OF 2
		REV. C



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

D2332-11 PROP
(D2332-1 SIMILAR)

DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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